Tuesday, 10/30/2007 2:49:05 PM Kim Johnston **Process Sheet** : PIN ASSEMBLY **Drawing Name** : CU-DAR001 Dart Helicopters Services Customer : 35441 Job Number **Estimate Number** : D3332041 Part Number P.O. Number S.O. No. : NA D3332 REV. A1 : 10/30/2007 **Drawing Number** This Issue Project Number : N/A Prsht Rev. : LARGE FAB ASSY Drawing Revision First Issue : NA Material Previous Run Each : 11/15/2007 Due Date Written By Checked & Approved By Comment : Est: 05.01.13 New issue KJ/JLM **Additional Product** Job Number: Machine Or Operation: Description: Seq. #: 1018-1025 Steel Bar M1018R0500 1.0 Comment: Qty.: Total: 1.9688 f(s) 0.3281 f(s)/Unit 1018-1025 Steel Bar Material: AISI 1018-1025 Ø0.500" Round Bar (M1018-R0.500) Identify for D3332-3 HARDINGE 2.0 Comment: HARDINGE CNC LATHE SMALL Machine D3332-3 as per Folio FA493 and Dwg D3332 3.0 QC2 Comment: INSPECT PARTS AS THEY COME OFF MACHINE SECOND CHECK 4.0 QC8 Comment: SECOND CHECK M1018R0313 1018-1025 Steel Bar 5.0 Comment: Qty.: 2.7563 f(s) 0.4594 f(s)/Unit Total: 1018-1025 Steel Bar Material: AISI 1018-1025 Ø0.313" Round Bar (M1018-R0.313) ly 07/11/19 Identify as D3332-5 Batch: <u>M 16634</u>

Dart Aerospace Ltd

W/O:			WORK ORDER CHANGES								
DATE	STEP	PRO	PROCEDURE CHANGE By		Ву	Date	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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QA: N/C Closed: ____ Date: ___

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NOTE: Date & initial all entries

Tuesday, 10/30/2007 2:49:05 PM Date: Kim Johnston User: **Process Sheet** Drawing Name: PIN ASSEMBLY ' Customer: CU-DAR001 Dart Helicopters Services Job Number: 35441 Part Number: D3332041 Job Number: Description: Seq. #: Machine Or Operation: LARGE FABRICATION RESOURCE 1 LARGE FAB 1 6.0 Comment: LARGE FABRICATION RESOURCE 1 Fabricate D3332-5 as per Dwg D3332 D33321 Handle Assembly 7.0 Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s) Handle Assembly Pick: Part Number Description 3 / B 35 489 Qty D3332-1 Handle A/R N/A Steel Rod Identify as D3332-041 LARGE FABRICATION RESOURCE 1 8.0 LARGE FAB 1 Comment: LARGE FABRICATION RESOURCE 1 Assemble and Weld using D3332-041T1 as per Dwg D3332 INSPECT WORK TO CURRENT STEP 9.0 Comment: INSPECT WORK TO CURRENT STEP POWDER COATING POWDER COATING 10.0 Comment: POWDER COATING Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3 Cover D3332-3 and cover thread only for D3332-5 prior to painting INSPECT POWDER COAT/CHEMICAL CONVERSION QC3 11.0 Comment: INSPECT POWDER COAT PACKAGING RESOURCE 12.0 PACKAGING 1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location:_

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W/O:		WORK ORDER CHA	NGES	······································			
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DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector		
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NOTE: Date & initial all entries

Date:

Tuesday, 10/30/2007 2:49:05 PM

User:

Kim Johnston

Process Sheet

* Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PIN ASSEMBLY

Part Number: D3332041

Job Number: 35441

Seq. #:

Job Number:

Machine Or Operation:

Description:

13.0

FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



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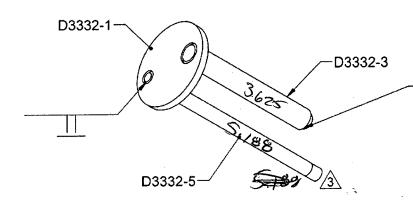
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NOTE: Date & initial all entries

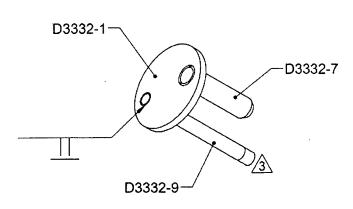


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	, ₩	F	IME)	D3332	SHEET 1 OF 4		
	DATE				TITLE	SCALE		
	04.12.14			PIN ASSEMBLY				
	Α	04	4.12.14		NEW ISSUE			
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1/8 CHAMFER AT THIS END

D3332-041 PIN ASSEMBLY



D3332-043 PIN ASSEMBLY

NOTES:

- 1) POSITION PARTS USING D3332-041T1
 2) WELD PER DART QSI 004
 3) MASK THREADS PRIOR PAINTING
 4) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER QSI 005 4.3
 (COVER THREAD ONLY FOR D3332-5/-9 PRIOR PAINTING)
 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 6) ALL DIMENSIONS ARE IN INCHES
 7) BREAK ALL SHARP EDGES 0.005 TO 0.10

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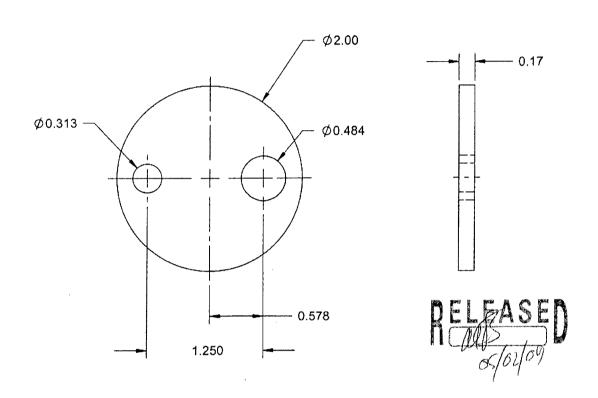
WORK ORDER

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D3332-1 HANDLE

NOTES:

1) MATERIAL: 1018-25 ROUND BAR STEEL PER MIL-S-7097
(REF. DART SPEC. M1018-R2.000)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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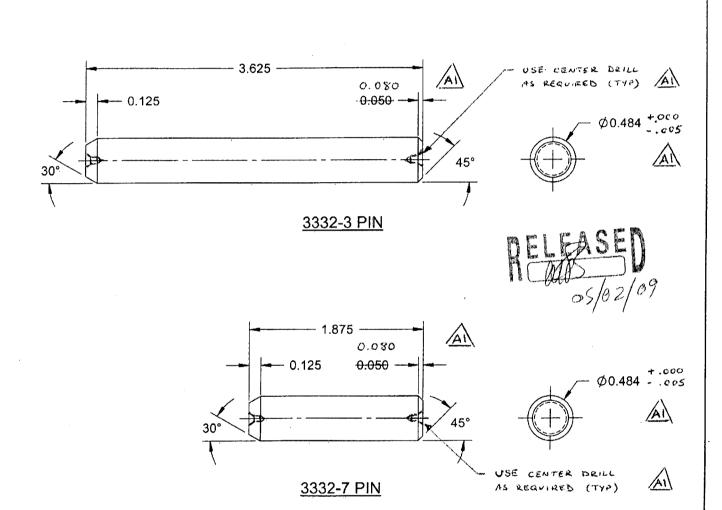
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DATE 04	.12.14	TITLE PIN ASSEMBLY	SCALE 1:1	



NOTES:

1) MATERIAL: 1018-1025 ROUND BAR STEEL PER MIL-S-7097

(REF. DART SPEC. M1018R0.500)

2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTEDICONTROLLED COPY SUBJECT TO AMENDMENT

3) ALL DIMENSIONS ARE IN INCHES

4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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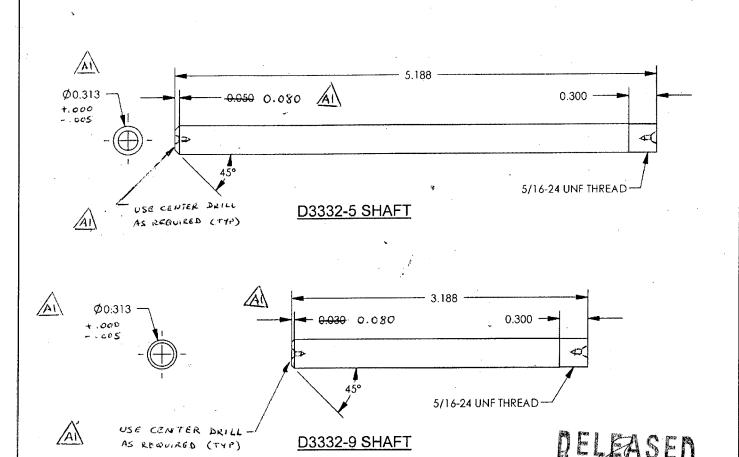
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DATE 04	.12.14	PIN ASSEMBLY	SCALE 1:1



NOTES:

1) MATERIAL: 1018-1025 ROUND BAR STEEL PER MIL-S-7097 (REF. DART SPEC. M1018-R0.313)

2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOPED COPY

3) BREAK ALL SHARP EDGES 0.005 TO 0.010 4) ALL DIMENSIONS ARE IN INCHES

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DART AEROSPACE LTD	Work Order:	35442
DAME ALMOGRAVE FIR	Part Number:	3332-3
Description: Pin	S. CHE SAMESAUMAN	
inspection Dwg: D3332 Rev: A1		Page 1 of 1

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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection		nments
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